

ork Order ID 71032

Tuesday, June 21, 2011 10:36:34 AM



Page 1

Item ID: D3197-041

Accept



Setup Start

Revision ID:

Stop

Item Name: Bar Assembly

Start Date: 6/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-21

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3197	Rev B								
100	BAND SAW	0.00							
	Bandsaw	0.00							
Jeaspa Bandsaw	Memo Cut blanks: 29.125" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00							
HAAS CNC vertical machine #1	Memo 1-Face ends to lenght per dwg D3197□2-Machine D3197-1 as per Folio FA340 and Dwg D3197□3-Debur								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								

B.A 11/07/13

B.A 11/07/22

B.A 11/07/22

6 0

6 0

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Lathe Conv

CONVENTIONAL LATHE

0.00

0.00

B.A 11/07/13

6 0

Conventional Lathe

Memo

Chamfer as per Dwg D3197

140



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

SL 11-07-25

6

Memo

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

6 0 11/07/20

Memo

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Setup Start



Revision ID:

Item Name: Bar Assembly

Stop



Start Date: 6/21/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/27/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

M117338

Memo

0.00

START TIME

9:00

□OVEN TEMPERATURE:

3:00 □FINISH TIME:

9:30

6 0 BK 11-7-25

Powder Coating

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

6 0 JU 4/04/25

Quality Control

180



Small Fab

Small Fab

0.00

Memo

0.00

Assemble D3197-041 as per Dwg D3197

9/5/08/09 6

Small Fab

W/O:		WORK ORDER CHANGES					
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Revision ID: Stop 
Item Name: Bar Assembly
Start Date: 6/21/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 6/27/2011 Req'd Qty: 6.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Subslog		(x6)			
200  Packaging Packaging	Identify as per dwg & Stock Location: 260 Memo	0.00 0.00							11/8/10 sl 60
210  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							GR 11/08/10 11-08-10 (6)

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NOTE: Date & initial all entries






Tuesday, June 21, 2011 10:36:41 AM

Parent Item Name: Bar Assembly

Required Date: 6/27/2011

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev:B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24 		Purchased	No			100	Each	110.0000	2	12			
Screw													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST292				110					
					100151			110					
AN960JD10 	NAS1149D0363J	Purchased	No			180	Each	0.0000	6	36			
Washer													
D2690-5 		Manufactured	No			180	Each	31.0000	2	12			
Lanyard Assembly													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST020				31					
					70390			31					
D3242-1 		Manufactured	No			180	Each	4.0000	2	12			
Tag													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				4					
					70154			4					
D3489-3-200 		Manufactured	No			180	Each	12.0000	2	12			
PIP PIN													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST062				12					
					70271			12					

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Picklist Print

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Page 2

Work Order ID: 71032

Parent Item: D3197-041

Parent Item Name: Bar Assembly



Start Date: 6/21/2011

Required Date: 6/27/2011

Start Qty: 6.00

Required Qty: 6.00

M7075T73R1.000

Purchased No

180 f

12.7150 2.42 18.15



7075-T73 Rd Bar 1.00



BA 11/07/13

Location

Loc Qty

Loc Code

✓ M118304 14.625^{ft}

MAT012

12.715

115165

2.7

116405

4.54

116604

2.25

116835

2.32

116962

0.905

MS21042L3

Purchased No

180 Each

2,077.000 2



Nut



12 5/25/08/09

Location

Loc Qty

Loc Code

ST300

2077

116549

377

117441

800

117601

400

117885

500

12

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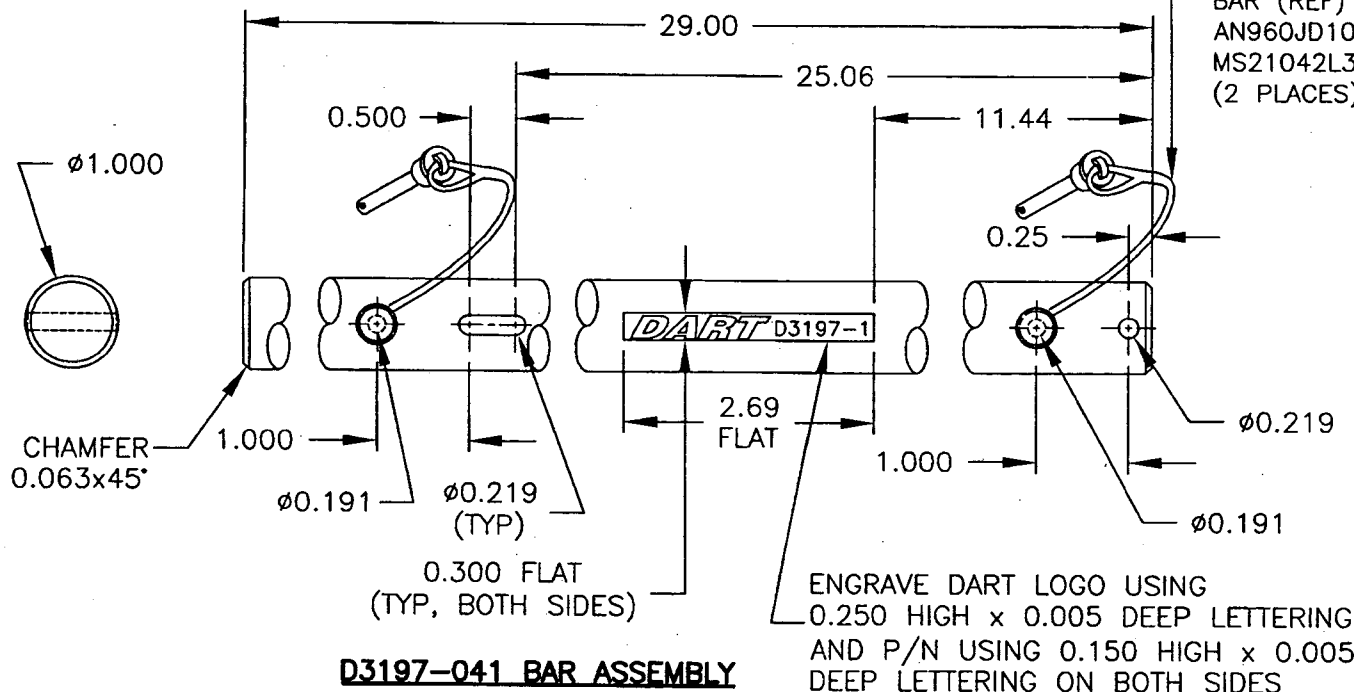
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RELEASED
06.03.21 CP
P/EIN 312

DART

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71032

1106-21

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3197
DATE	06.01.10	TITLE	BAR	REV. B
A	03.07.01	NEW ISSUE		SHEET 1 OF 1
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG		SCALE 1:1

W/O:		WORK ORDER CHANGES					
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